Work Order ID 62862

Tuesday, October 12, 2010 11:44:54 AM

Item ID: D2989-043 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Basket Lid Assembly

Start Date: 10/12/2010 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 10/22/2010 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** 10-10-10 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2989	Rev D								
100	Large Fab	0.00							
Large Fab									
Large Fab	**Memo**	0.00							

1- assemble all ribs in DT9446 jig, weld as per dwg D2989
2- tack weld mesh on basket as per dwg D2989 using DT9446 jig
3- to locate hinges and shims use D2989-041, weld as per dwg D2989
A/R ER316 S.S. Rod Batch: ~~111585~~

10-10-09

BE 10-11-09

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC									
Quality Control	**Memo**	0.00							

1 of 1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 62862

Tuesday, October 12, 2010 11:44:54 AM

Item ID: D2989-043 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Basket Lid Assembly

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Required Date: 10/22/2010 **Req'd Qty:** 1.00

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00				40			
QC	**Memo**	0.00							
Quality Control									
125	Pressure Wash per QSI005 4.3	0.00				0			
HandFinish	**Memo**	0.00							
Hand Finishing									

10/11/10

BR 10-11-10.

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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NOTE: Date & initial all entries

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Item Name: Basket Lid Assembly

Start Date: 10/12/2010 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 10/22/2010 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00				1			BK 10-11-10.
Powdercoat	**Memo**	0.00							
Powder Coating	1- Plug holes prior to powder coating 2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989 M115291 1ST COAT START TIME: 2:05 OVEN TEMPERATURE: 400° FINISH TIME: 2:35 ********** 2nd coat if necessary********** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____								
140	QC3- Inspect Part Finish	0.00							EJS 10/11/10
QC	**Memo**	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

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Cust Item ID:

Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: G-A	0.00							
Packaging									
Packaging	**Memo** w/o 62848	0.00							
160	QC21- Final Inspection - Work Order Release	0.00							
QC									
Quality Control	**Memo**	0.00							

10/11/16 O

CK 10/11/17

BS 10-11-17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Tuesday, October 12, 2010 11:45:00 AM

Work Order ID: 62862

Parent Item: D2989-043

Parent Item Name: Basket Lid Assembly

Start Date: 10/12/2010 **Required Date:** 10/22/2010

Start Qty: 1.00 **Required Qty:** 1.00

Comments:
IPP Rev:I Removed D2989-041 05-11-03 JLM
IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC
IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1 Rib		Manufactured	No			100	Each	14.0000	1	1			
				Location			**Loc Qty**		**Loc Code**				
				WA			14						
					61091		2						
					61424		12						
D2989-3 Rib		Manufactured	No			100	Each	5.0000	1	1			
				Location			**Loc Qty**		**Loc Code**				
				WA			5						
					59006		1						
					59034		1						
					61393		3						
D2989-4 Rib		Manufactured	No			100	Each	3.0000	1	1			
				Location			**Loc Qty**		**Loc Code**				
				WA			3						
					61394		3						

B62519 → (1)

B62998 → (1)

B62995 → (1)

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, October 12, 2010 11:45:00 AM

Work Order ID: 62862

Parent Item: D2989-043

Parent Item Name: Basket Lid Assembly

Start Date: 10/12/2010 **Required Date:** 10/22/2010

Start Qty: 1.00 **Required Qty:** 1.00

D2989-5	Manufactured	No		100	Each	8.0000	2	2
Rib								

Location	Loc Qty	Loc Code
WA	8	
61396	4	
62367	4	

D3182-1	Manufactured	No		100	Each	12.0000	2	2
Hinge								

Location	Loc Qty	Loc Code
WA	12	
61395	2	
62358	6	
62365	4	

D3442-3	Manufactured	No		100	Each	6.0000	2	2
Shim								

Location	Loc Qty	Loc Code
WA	6	
61176	4	
61756	2	

D3827-041	Manufactured	No		100	Each	9.0000	1	1
Rib Assembly (Inboard)								

Location	Loc Qty	Loc Code
WA	9	
61177	3	
61758	6	

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Tuesday, October 12, 2010 11:45:00 AM

Work Order ID: 62862

Parent Item: D2989-043

Parent Item Name: Basket Lid Assembly

Start Date: 10/12/2010 **Required Date:** 10/22/2010

Start Qty: 1.00 **Required Qty:** 1.00

D3832-5	Manufactured	No	100	Each	4.0000	1	1	
Mesh (Lid)								

Location	Loc Qty	Loc Code
WA	4	
60671	1	
61759	3	

D3833-5	Manufactured	No	100	Each	7.0000	2	2	
Mesh (Lid End)								

Location	Loc Qty	Loc Code
WA	7	
53722	1	
60673	2	
61317	4	

D3838-041	Manufactured	No	100	Each	3.0000	1	1	
Rib Assembly (Basket Lid, LH)								

Location	Loc Qty	Loc Code
WA	3	
61397	3	

D3838-042	Manufactured	No	100	Each	1.0000	1	1	
Rib Assembly (Basket Lid, RH)								

Location	Loc Qty	Loc Code
WA	1	
61398	1	

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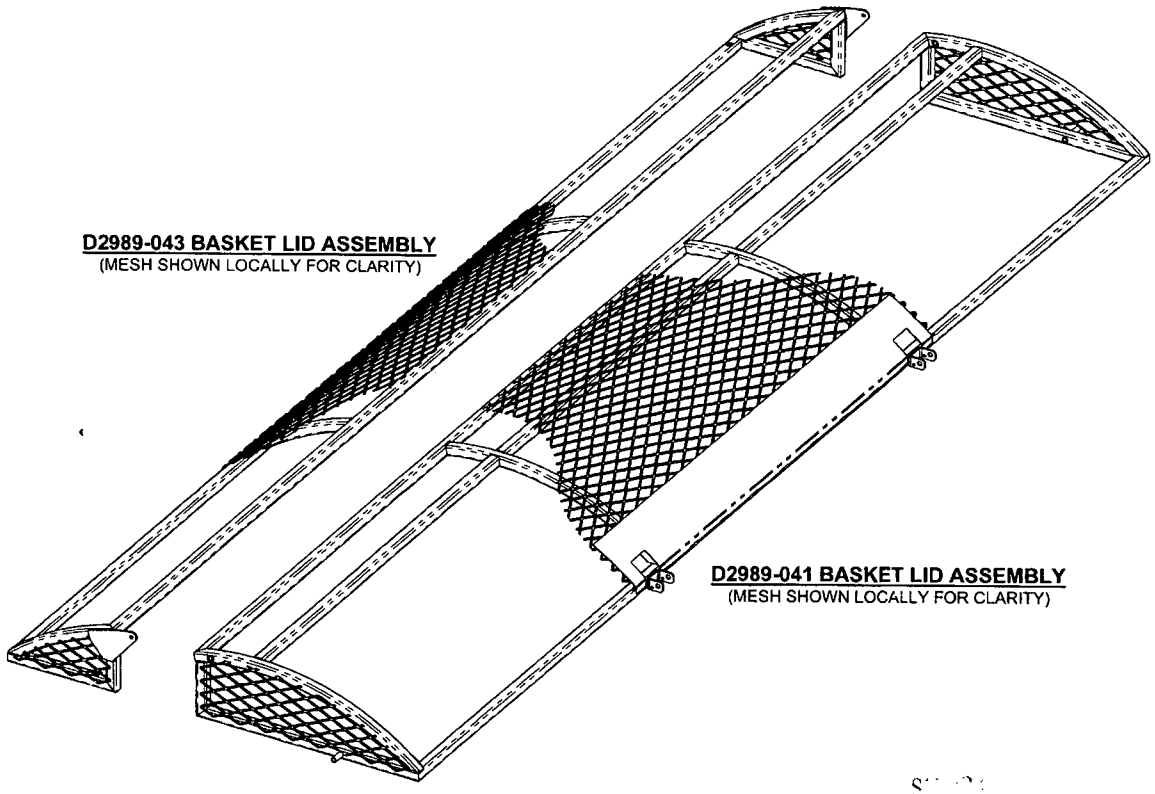
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Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		**D2989-041**	**BASKET LID ASSEMBLY**
2		X	**D2989-043**	**BASKET LID ASSEMBLY**
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED
08/11/18 MP

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
8) WELD PER DART QSI 004

REV.	DESCRIPTION	BY	DATE
D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG), D2989-9/-10 (NOW ON D3836 DWG), D2989-1/-2/-7/-15 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27

DESIGN	DS	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D2989 REV. D
MFG. APPR.		SHEET 1 OF 5
APPROVED		TITLE BASKET LID ASSEMBLY SCALE NTS
DE APPR.		
DATE	08.09.24	

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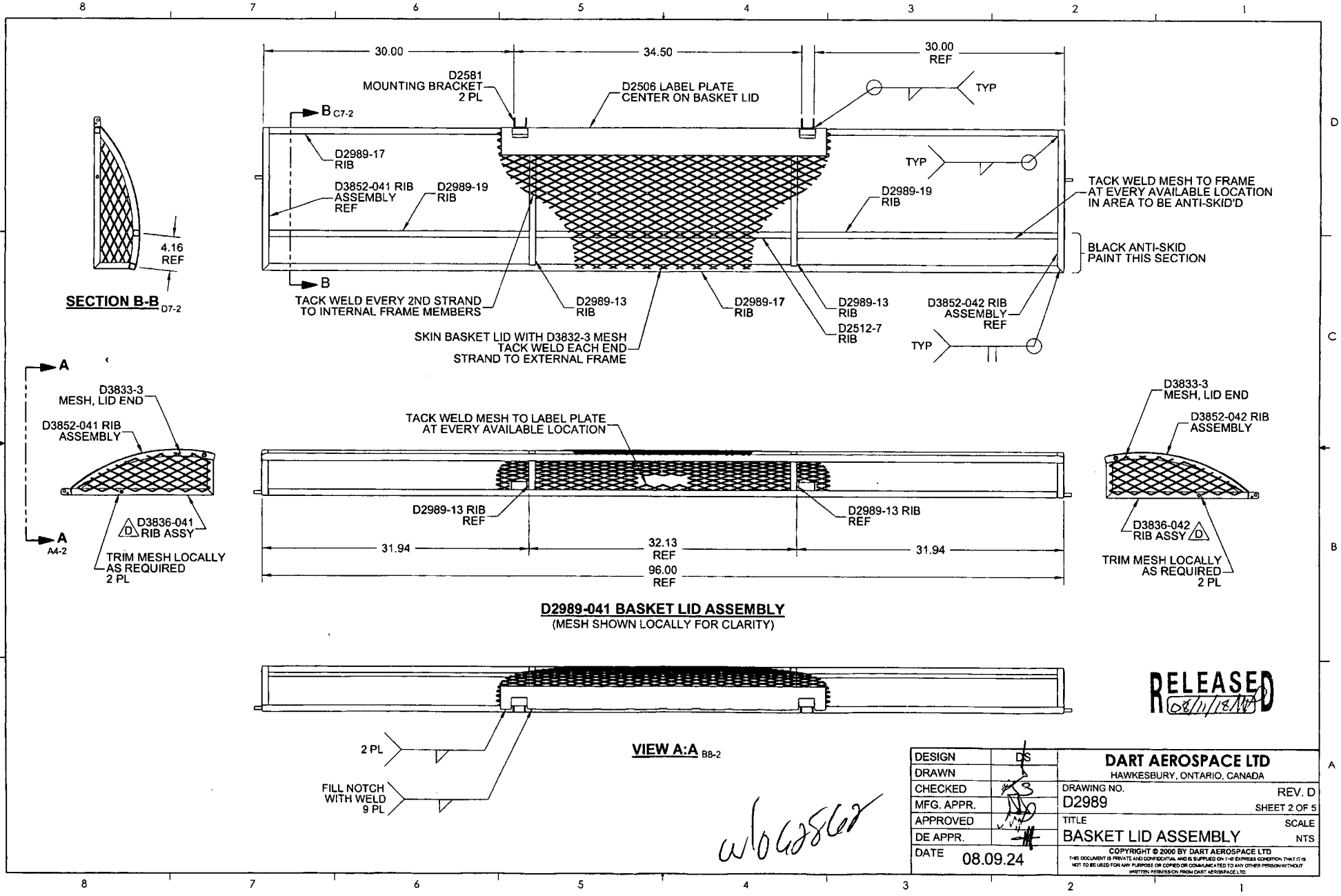
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

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Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries



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w/o 638662

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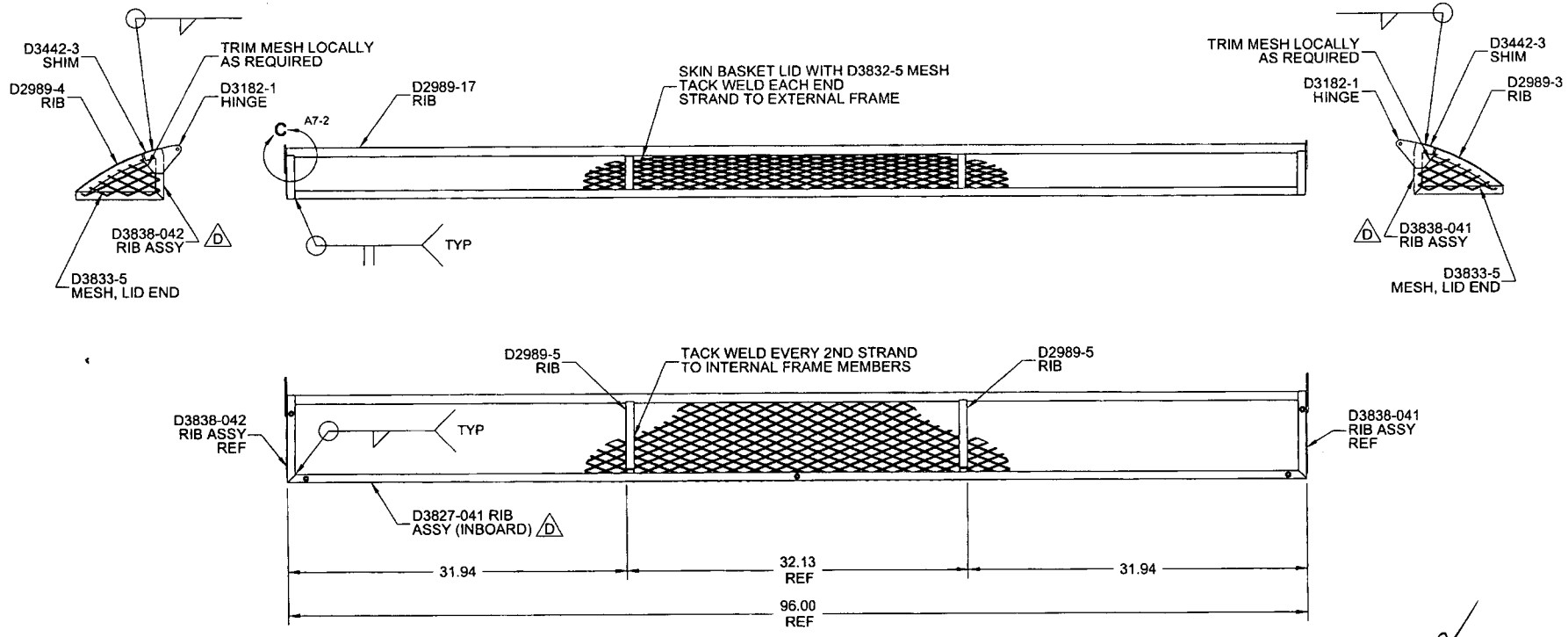
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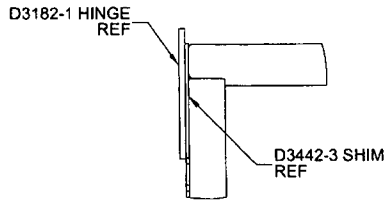
NOTE: Date & initial all entries



D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

w/o 68562

RELEASED
08/11/18



DETAIL C D7-2
TYP, SCALE 4X

DESIGN	DS	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D2989 REV. D
MFG. APPR.		SHEET 3 OF 5
APPROVED		TITLE BASKET LID ASSEMBLY SCALE NTS
DE APPR.		
DATE	08.09.24	

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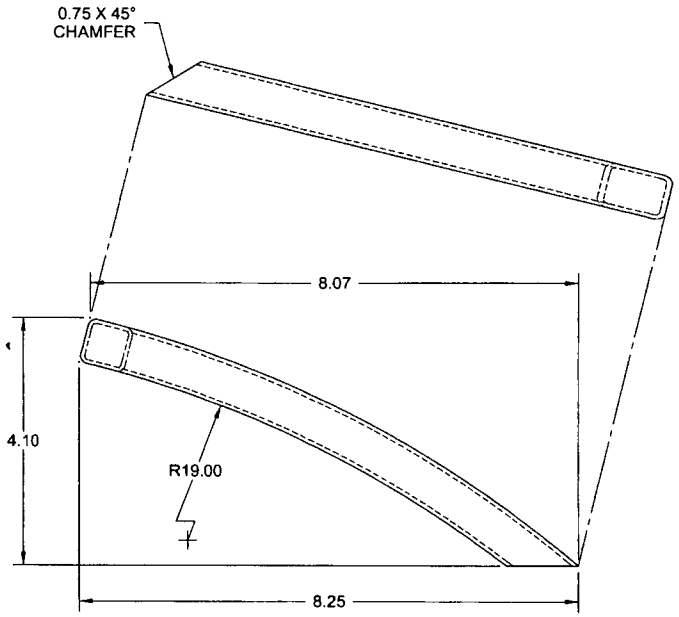
W/O:		WORK ORDER CHANGES					
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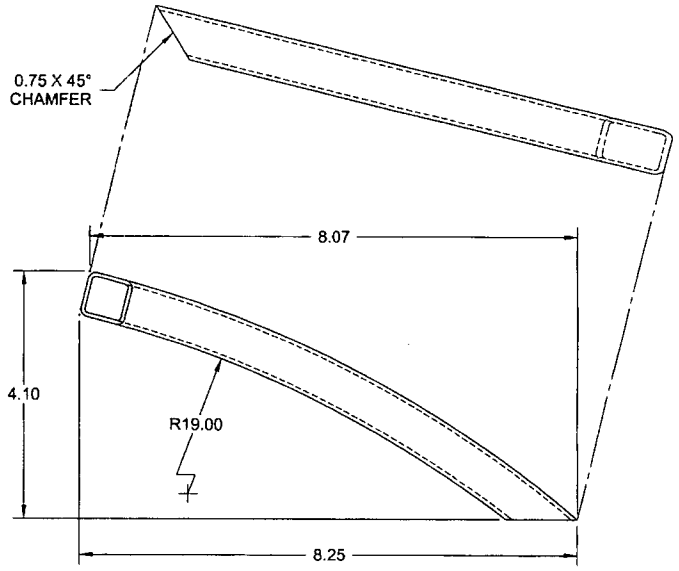
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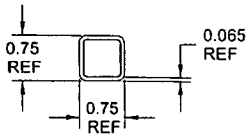
D2989-3 RIB



D2989-4 RIB

w/o G3862

RELEASED
08/11/18 NW



TYPICAL SECTION VIEW

NOTES:
1) MATERIAL: D3166-3 BASKET HOOP
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
8) WEIGHT: D2989-3/-4 = 0.39 lbs;

DESIGN	DS	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		DRAWING NO. D2989 REV. D
CHECKED		SHEET 4 OF 5
MFG. APPR.		TITLE BASKET LID ASSEMBLY SCALE NTS
APPROVED		
DE APPR.		
DATE	08.09.24	

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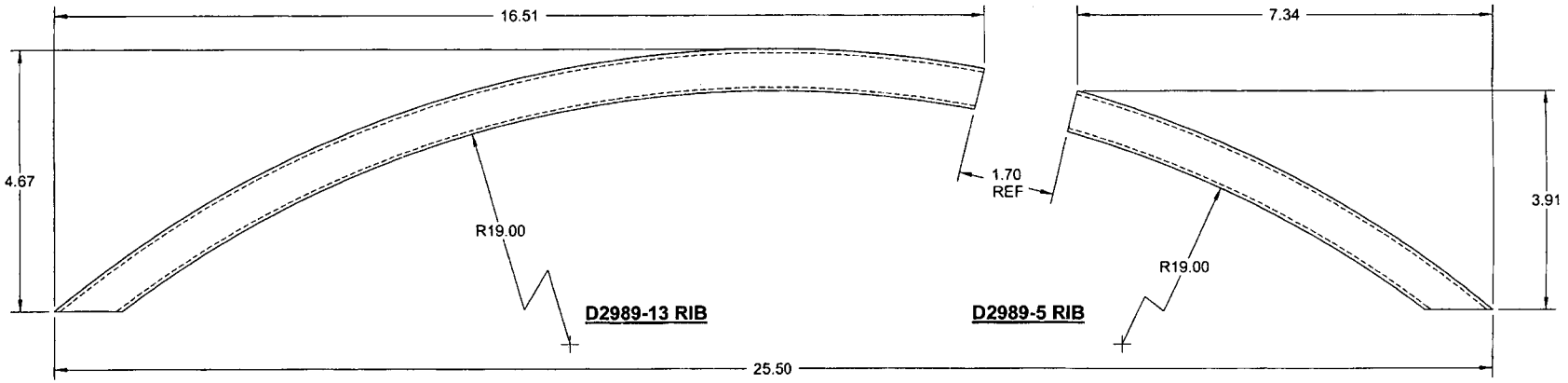
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

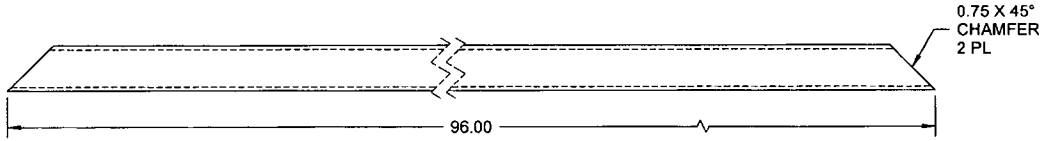
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



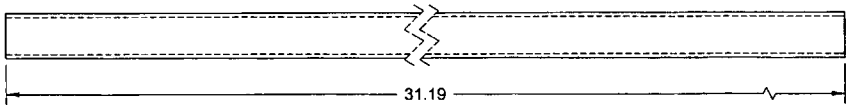
D2989-13 RIB

D2989-5 RIB

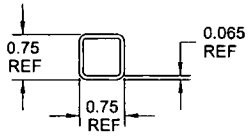


D2989-17 RIB

wo 62862



D2989-19 RIB



TYPICAL SECTION VIEW

RELEASED
08/11/18 JW

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
8) WEIGHT: D2989-5 = 0.37 lbs; D2989-13 = 0.81 lbs; D2989-17 = 4.57 lbs; D2989-19 = 1.50 lbs

DESIGN	DS
DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	08.09.24

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D2989 REV. D
SHEET 5 OF 5
TITLE BASKET LID ASSEMBLY SCALE NTS

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries